

Date: Monday, 11/19/2007 4:01:55 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP WELDMENT	
Job Number	35821			07.11.20 DC		
Estimate Number	12576			Part Number	D3562041	
P.O. Number	N/A			Drawing Number	D3562 UNDER REVIEW	
This Issue	11/19/2007	S.O. No.	N/A	Project Number	OK PER REV. C ENSURE D2808 SPACER	
Prsht Rev.	NC	Type			LARGE FAB ASSY	IS PRESS FIT BEFORE POWDER COAT
First Issue	N/A				Material	N/A
Previous Run	35401				Due Date	12/12/2007
Written By				Qty:	5	Um: Each
Checked & Approved By	07.11.20					
Comment	Est Rev: A	New Issue	06-11-09	JLM		
	Est rev B	ECN 987	07.10.09	EC	verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion B34694 Check Material for any Dents or Defects a.m 07.11.29 5 10
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622 extrusion as per Dwg D3562 a.m 07.12.03 5 2-Deburr and bevel ends for welding a.m 07.12.03 5
3.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 5 2/2/03 x5
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1 a.m 07.12.04 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP WELDMENT
Job Number: 35821		Part Number: D3562041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>12/12/12</i>
6.0	D3560041	ARM WELDMENT 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) ARM WELDMENT Batch: <i>B350293X</i>		<i>2KB35295 a.m 07.12.12 (5)</i>
7.0	D3560043	ARM WELDMENT 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) ARM WELDMENT Batch: <i>B35031</i>		<i>a.m 07.12.12 (5)</i>
8.0	MS20600AD4W5	Blind Rivet 
Comment: Qty.: 26.0000 Each(s)/Unit Total : 180.0000 Each(s) Blind Rivet <i>32.00</i> batch: <i>M106375</i>		<i>a.m 07.12.12 (5)</i>
9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1- Transfer drill Rivet holes as per dwg D3562.		<i>a.m 07.12.13 (5)</i>
2-Touch-up rivet holes with alodine as per dwg d3562		<i>a.m 07.12.13 (5)</i>
3-Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond*****		<i>a.m 07.12.13 (5)</i>
A/R	Magnabond 6398	Batch: <i>M105379</i> a.m 07.12.13 (5)
10.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>12/12/12 (5)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP WELDMENT
Job Number: 35821		Part Number: D3562041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
11.0	D2734	206 Step Endplate 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>334485</u>		 <i>11/201-12-19</i>
12.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/R Aluminum Rod <u>m105058</u> <i>11/201-12-19</i>		
2-Grind end cap welds flush as per Dwg D3562 <i>Q.R 07.12.20</i>		
13.0	QC9 	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION <i>11/201-12-20 (5)</i>		
14.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP <i>11/201-12-20 (5)</i>		
15.0	POWDER COATING 	POWDER COATING Touch-up alodine M-1 <i>11/201-12-21 (5)</i> <u>m106379</u>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>BR 07-12-21</i>		
16.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3562 and QSI 005 4.4 Batch: <u>m106332</u> <i>Q.R 07.12.24 (5)</i>		
17.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>m108/01/10 (3)</i>		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 08/01/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:01:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35821

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

GA 11/08/01/10 X3

19.0 QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

11/08/01/11

Job Completion



11/08/01/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

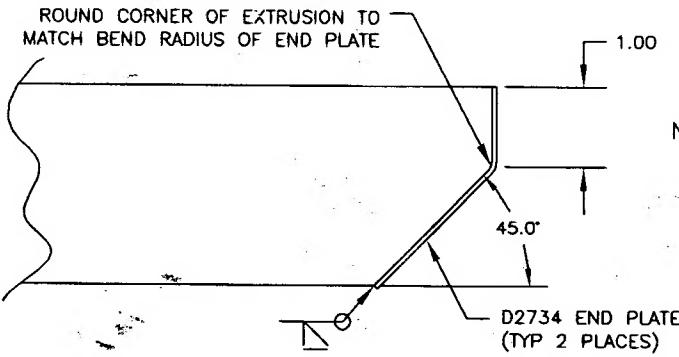
DART

RELEASED

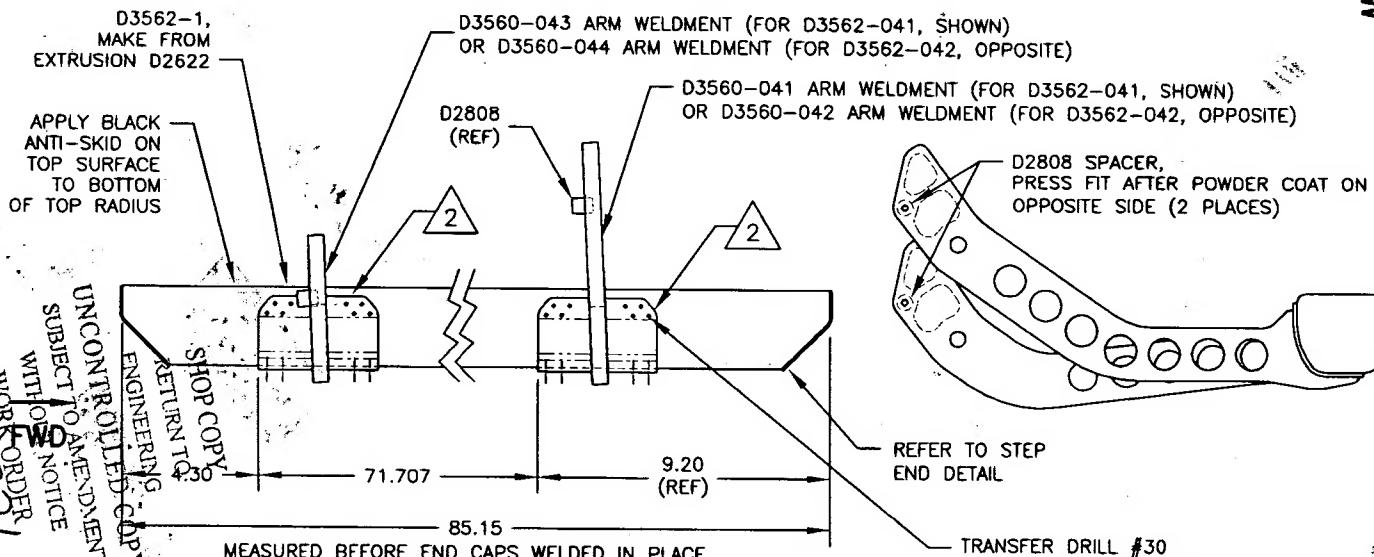
07.06.2010

UNDER REVIEW

07/06/2010
OK PER REV C
07.11.2010 SC



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1), OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
	D3562	
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RIVTS
		SHEET 1 OF 1
		SCALE
		NTS